

Amendments to the Claims:

This listing of claims will replace all prior versions, and listings, of claims in the application:

Listing of Claims:

1. (Currently amended) A five layer shrink film for high speed packaging lines having a modulus of 50,000 psi or higher and a haze value less than 5.0 comprising:
a first outer [high speed polyethylenic] layer comprising by total weight of the layer, 60% or more by weight polyethylenic polymer that has been formulated for use as outer layers in high speed packaging shrink film and further comprises 5% to 15% by weight softening olefin and 10% to 30% by weight cyclic-olefin copolymers;
a second outer [high speed polyethylenic] layer comprising by total weight of the layer, 60% or more by weight polyethylenic polymer that has been formulated for use as outer layers in high speed packaging shrink film and further comprises 5% to 15% by weight softening olefin and 10% to 30% by weight cyclic-olefin copolymers;
a core cyclic-olefin copolymer containing layer;
a first cyclic-olefin copolymer containing intermediate layer between the core [cyclic-olefin copolymer containing] layer and the first outer [high speed polyethylenic] layer; and
a second cyclic-olefin copolymer containing intermediate layer between the core [cyclic-olefin copolymer containing] layer and the second outer [high speed polyethylenic] layer;

[wherein the high speed ethylenic layers comprise by weight 75% to 95% linear low density polyethylene, from 0% to 15% cyclic olefin copolymer and from 0% to 10% softening olefin copolymer;]
wherein the cyclic-olefin copolymer of the five layer shrink film is a single-site catalyzed cyclic-olefin copolymer;
wherein softening olefin copolymer comprises by total weight of the five layer shrink film from 2% to 25%;
wherein the cyclic-olefin copolymer comprises by total weight of the five layer shrink film from 10% to 30%; and
wherein the five layer shrink film comprises less than 1% by weight polystyrene and less than 1% by weight polypropylene.

2. (Currently amended) The film of claim 1 wherein the polyethylenic polymer is linear low density polyethylene copolymer and comprises 1 to 10 weight percent 1-octene monomer.
3. (Original) The film of claim 1 having a thickness between 0.30 and 2.0 mils.
4. (Currently amended) The film of claim 1 wherein the first outer [high speed polyethylenic] layer comprises from 10% to 20% of the total weight of the film; wherein the second [high speed polyethylenic] outer layer comprises from 10% to 20% of the total weight of the film; wherein the core [inner most cyclic-olefin copolymer containing] layer comprises from 30% to 60% of the total weight of the film, wherein the first [cyclic-olefin copolymer containing] intermediate layer comprises from 10% to 20% of the total weight of the film; and wherein the

second [cyclic-olefin copolymer containing] intermediate layer comprises from 10% to 20% of the total weight of the film.

5. (Original) The film of claim 1 crosslinked using a radiation source.
6. (Original) The film of claim 5 wherein the radiation source is active on the first collapsed tube of a double-bubble film orientation process.
7. (Original) The film of claim 5 wherein the radiation source is active on the film subsequent to full biaxial orientation.
8. (Currently amended) A three layer shrink film for high speed packaging lines having a modulus of 50,000 psi or higher and a haze value less than 5.0 comprising:
a first outer [high speed polyethylenic]layer comprising by weight 75% to 95% linear low density polyethylene, from 1% to 15% cyclic-olefin copolymer and from 1% to 25% softening olefin copolymer;
a second outer [high speed polyethylenic]layer comprising by weight 75% to 95% linear low density polyethylene, from 1% to 15% cyclic-olefin copolymer and from 1% to 25% softening olefin copolymer;
a core cyclic-olefin copolymer containing layer;
[wherein the high speed ethylenic layers comprise by weight 75% to 95% linear low density polyethylene, from 0% to 15% cyclic olefin copolymer and from 0% to 25% softening olefin copolymer;]
wherein the cyclic-olefin copolymer of the three [five] layer shrink film is a single-site catalyzed cyclic-olefin copolymer;
wherein softening olefin copolymer comprises by total weight of the three [five]

layer shrink film from 2% to 25%;

wherein the cyclic-olefin copolymer comprises by total weight of the three [five]

layer shrink film from 10% to 30%; and

wherein the three [five] layer shrink film comprises less than 1% by weight

polystyrene and less than 1% by weight polypropylene.

9. (Original) The film of claim 8 wherein the linear low density polyethylene copolymer comprises 1 to 10 weight percent 1-octene monomer.
10. (Original) The film of claim 8 having a thickness between 0.30 and 2.0 mils.
11. (Currently amended) The film of claim 8 wherein the first [high speed polyethylenic]outer layer comprises from 10% to 20% of the total weight of the film; wherein the second [high speed polyethylenic]outer layer comprises from 10% to 20% of the total weight of the film; and wherein the [innermost cyclic-olefin copolymer containing] core layer comprises from 60% to 80% of the total weight of the film.
12. (Original) The film of claim 8 crosslinked using a radiation source.
13. (Original) The film of claim 12 wherein the radiation source is active on the first collapsed tube of a double-bubble film orientation process.
14. (Original) The film of claim 12 wherein the radiation source is active on the film subsequent to full biaxial orientation.
15. (Original) A method of forming the film of claim 1, the method comprising of: feeding individual layer compositions into 3 or more separate extruders; extruding the compositions simultaneously into a biaxial film orienting means; and

biaxially orienting the film to a thickness of 30 to 200 gauge;
wherein a separate extruder extrudes a single homogenous composition.

16. (Original) The method of claim 15 wherein the biaxial film orienting means
consists of a double-bubble film orienting process.

17. (Original) The method of claim 15 further comprising the step of crosslinking the
layers by exposing the layers to radiation dosage.

18. (Original) The method of claim 17 wherein the radiation dosage is active on the
film subsequent to full biaxial orientation.

19. (Original) The method of claim 16 further comprising the step of crosslinking the
layers by exposing the layers to radiation dosage.

20. (Original) The method of claim 19 wherein the radiation dosage is active on the
first collapsed tube of a double-bubble film orientation process.

21. (Original) A method of forming the film of claim 8, the method comprising of:
feeding individual layer compositions into 2 or more separate extruders;
extruding the compositions simultaneously into a biaxial film orienting means;
and
biaxially orienting the film to a thickness of 30 to 200 gauge;
wherein a separate extruder extrudes a single homogenous composition.

22. (Original) The method of claim 21 wherein the biaxial film orienting means
consists of a double-bubble film orienting process.

23. (Original) The method of claim 21 further comprising the step of crosslinking the
layers by exposing the layers to radiation dosage.

24. (Original) The method of claim 23 wherein the radiation dosage is active on the film subsequent to full biaxial orientation.
25. (Original) The method of claim 22 further comprising the step of crosslinking the layers by exposing the layers to radiation dosage.
26. (Original) The method of claim 25 wherein the radiation dosage is active on the first collapsed tube of a double-bubble film orientation process.